

Work Order ID 144036

Wednesday, March 30, 2016 2:24:04 PM

144036

Page 1

Item ID: D4101-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spring
 Start Date: 4/4/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 4/8/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: *M* Date: 16-3-30 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4101	C								

100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4101 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

(21) _____ ac 16/04/05

(21) _____ ac 16/04/05

(21) _____
 DAS
 38
 9-89
 APR 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 144036***144036***

Page 2

Wednesday, March 30, 2016 2:24:04 PM

Item ID: D4101-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spring

Start Date: 4/4/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location: ST079

0.00

150

Packaging

Memo

0.00

Packaging

21

APR 05 2016

DAS

6

3-89

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ

APR 06 2016

MLJ

APR 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Picklist Print

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Page 1

Work Order ID: 144036

144036

Parent Item: D4101-5

D4101-5

Parent Item Name: Spring

Start Date: 4/4/2016

Required Date: 4/8/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 10.07.07 new issue DD verf:EC
10.09.07 revB DD verf:EC

IPP Rev:A

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINS0.125		Purchased		No			sf	6.0900		0.252632			

MDFI RINS0 125

Black Delrin Sheet .125

22/6/07/05

Location

Loc Qty

Loc Code

MAT019

6.09

119256

1.4

124463

4.69

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

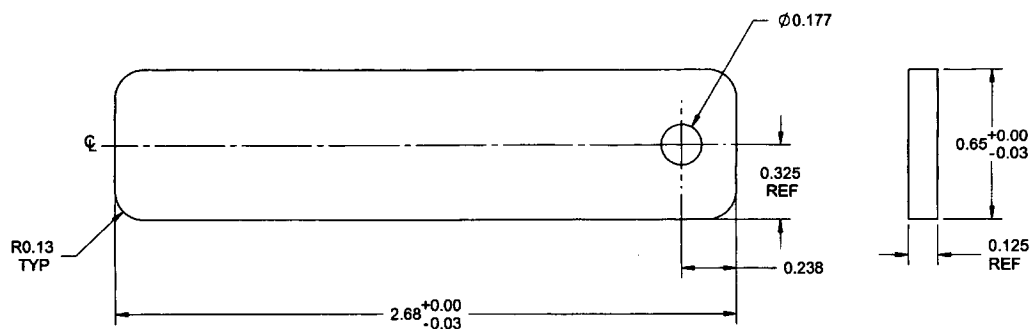
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Marks/Chatter ☐																																																																									
Temperature/Cure ☐																																																																									
Set-up ☐																																																																									
BOM/Route ☐																																																																									
Broken/Damage/Defect ☐																																																																									
Inspection Incomplete/Unqualified ☐																																																																									
Contamination ☐																																																																									
Countersink ☐																																																																									
Cut Too Short ☐																																																																									
Instructions Incomplete/Unclear ☐																																																																									
Drill Holes ☐																																																																									
Power Loss/Surge ☐																																																																									
Folio/Program ☐																																																																									
Grain ☐																																																																									
Weld ☐																																																																									
Wrong Stock Pulled ☐																																																																									
Out of Sequence ☐																																																																									
Off-set ☐																																																																									
Mislabeled ☐																																																																									
Fit/Function ☐																																																																									
Misaligned/off center ☐																																																																									
Positioned Wrong ☐																																																																									
Outside Dimensions ☐																																																																									
Over/Under tolerance ☐																																																																									
Part Incorrect ☐																																																																									
Part Lost/Missing ☐																																																																									
Part Moved ☐																																																																									
Drawing ☐																																																																									
Finish ☐																																																																									
Misread ☐																																																																									
Turning Sequence ☐																																																																									
		OTHER : ☐																																																																							

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <i>ac</i>		Audited by: DAS 38		Preliminary Approval:	
Date: <i>16/08/05</i>		Date: <i>APR 15 2016</i>		Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>



D4101-5 SPRING



NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL SHEET, BLACK, 0.125 THICK
REF DART SPEC M-DELRIN-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

16-3-30
144036

RELEASED
2016-03-29

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4101	SHEET 5 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DE	PRE-FLIGHT STEP ASSEMBLY	NTS
DATE	15.10.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	